

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 30952	
Estimate Number : 11216	
P.O. Number : N/A	Part Number : D33335
This Issue : 2/23/2007 S.O. No. : N/A	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28617	Material : N/A
Written By : _____	Due Date : 3/20/2007 Qty: 20 Um: Each
Checked & Approved By : <u>HJ 07.02 26</u>	
Comment : Est. A 05.01.13 New issue KJ/JLM	

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M1010B1500X01000	AISI 1010-1025 Steel Bar
<p>Comment: Qty.: 0.6672 f(s)/Unit Total : 13.3434 f(s)</p> <p>AISI 1010-1025 Steel Bar</p> <p>Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel</p> <p>(M1010-B1.500x01.000)</p> <p>Identify for D3333-5</p> <p>Batch: <u>M102210</u></p>		
2.0	BAND SAW	BAND SAW
<p>Comment: BAND SAW</p> <p>Cut blanks: 1.500" x 1.000" thick x 7.500" long</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>Machine as per Folio FA484 and Dwg D3333</p> <p>Tap holes as per Dwg D3333 * <u>DSP 07/03/06</u></p> <p>Deburr</p> <p>Identify as D3333-5</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 2:00:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 30952

Part Number: D33335

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/06

(20)

6.0

POWDER COATING

POWDER COATING



M18052



(20X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Ensure to mask threaded holes

M-A redo

07/03/15
07/03/09

(PIU)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 07/03/14 (20) M

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

CP 07/03/16 (20) M

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



U 07.03.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/19

QA: N/C Closed: _____ Date: _____

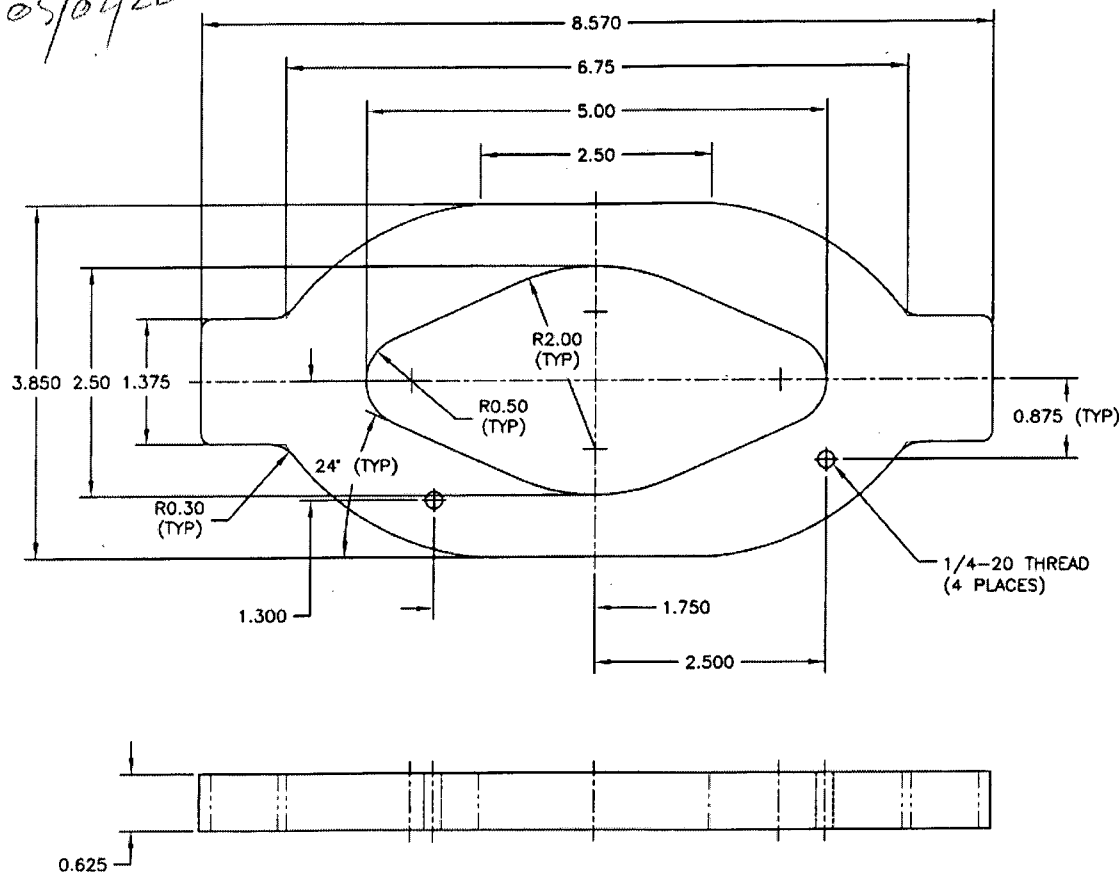
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0703-12	60	The carbon on the parts came through & bubbled on the powder coat.	2 QS1042	Ground off paint and the carbon. Clean parts, and re powder coat as per QS1005	MJR 07/03/15	2 0703-15	2 QS1042	2 0703-12

NOTE: Date & initial all entries



DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED TJ	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-1B) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSP 005-4-3
- 3) TOLERANCES ARE PER DART QSP 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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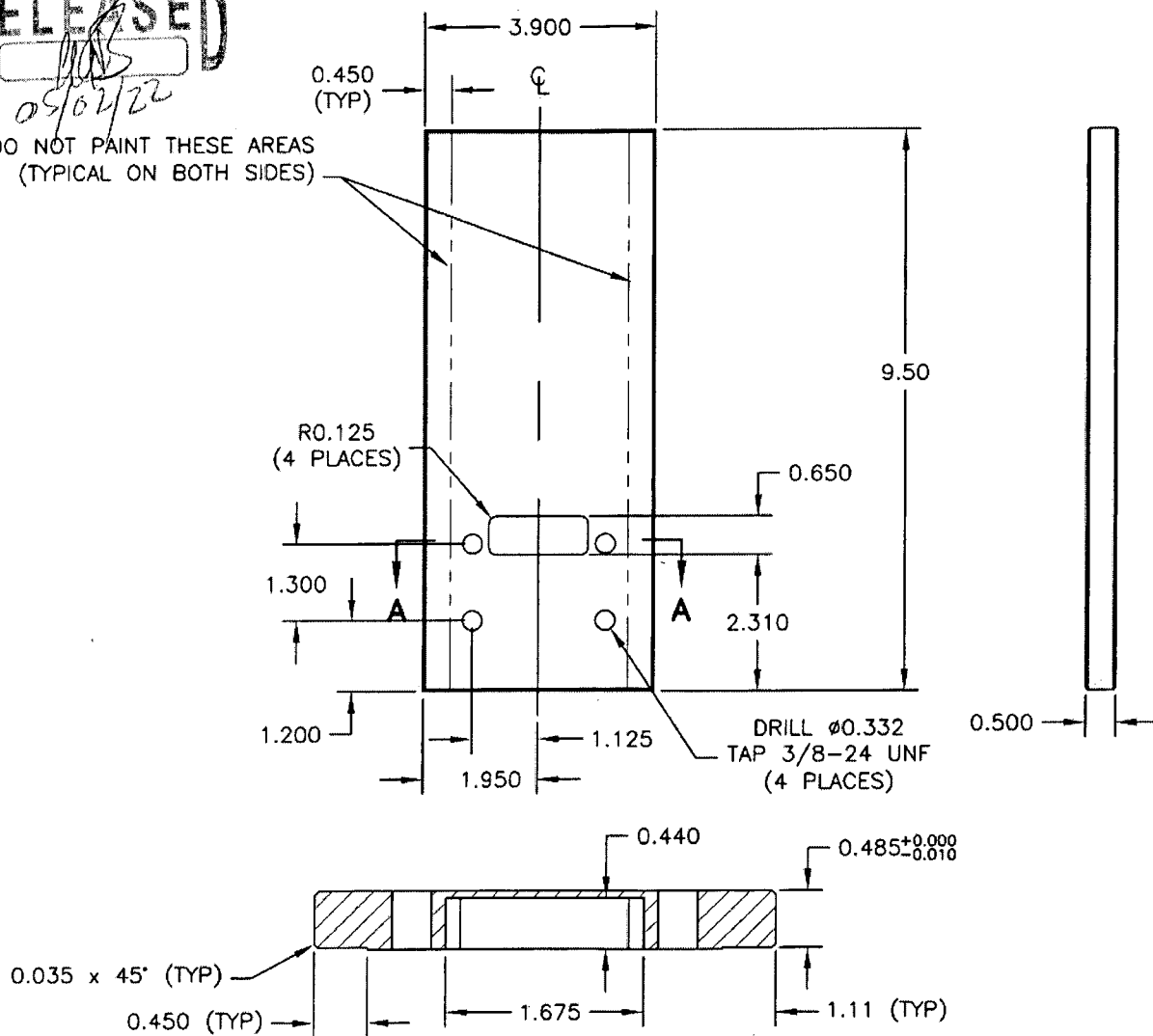
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RELEASED
[Signature]
05/02/22

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

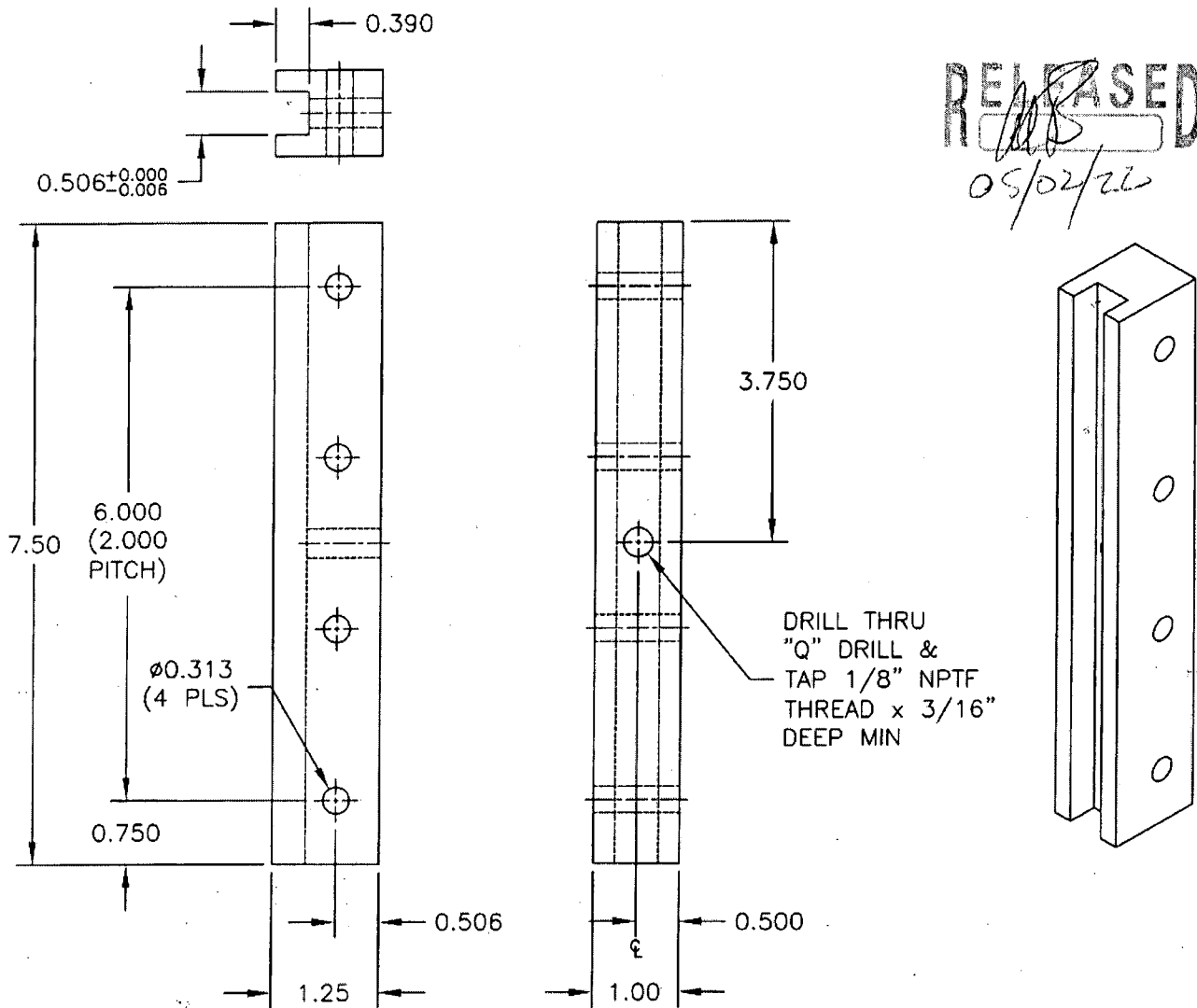
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DATE 05.02.18	TITLE PLATE	SCALE 1:2	



D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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